

Work Order ID 73160

Friday, August 26, 2011 7:10:51 AM



Page 1

Item ID: D3777-041

Accept



Setup Start



Revision ID:

Item Name: Clamp

Stop



Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

MK

Date:

11-08-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3777

Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3777-1 ☐ Dwg Rev: *A* ☐ Prog Rev: *A* ☐ 2-
Deburr if necessary

304.032

B 11-8-30



110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 11-8-30

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8/26/31

counted
120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Stop



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Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- Deburr any rough edges 2- Form as per Dwg D3777								
				SB 11/09/26					
140		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble rubber cushion as per dwg D3777								
				SB 11/09/26					

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3777-041

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Setup Start



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Stop



Item Name: Clamp

Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulor 127



170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/9/27 SL 600

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/27 JF

ME 11-09-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:10:47 AM

Page 1

Work Order ID: 73160

Parent Item: D3777-041

Parent Item Name: Clamp





Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue 08-05-26 DD verified by:EC
IPP Rev:B 08-10-20 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B013  Rubber cushion		Manufactured	No			100	Each	0.0000	1	6			
M304S22GA  304/316 .032 Sheet		Purchased	No			150	sf	141.3600	0.02	0.126316			

B66063

SA 8/29/28

B11-8-30

Location

Loc Qty

Loc Code

020

4.3

109057

4.3

MAT020

137.06

117379

33.56

118271

96

118400

7.5

109057

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 73160
Description: CLAMP	Part Number: D3777-04
Inspection Dwg: D3777-1, Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

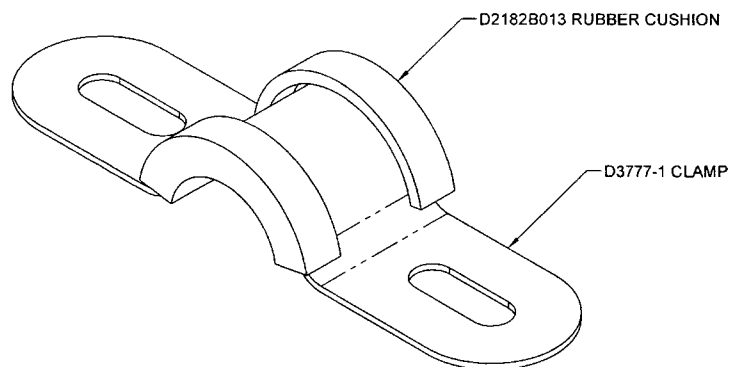
X

[illegible]

Measured by: B	Audited by: E	Prototype Approval:
Date: 11-8-30	Date: 11/6/31	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

QTY	P/N	DESCRIPTION
-041		
X	D3777-041	CLAMP
1	D3777-1	CLAMP
1	D2182B013	RUBBER CUSHION



D3777-041 CLAMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3777	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
DATE	08.04.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

RELEASED
08-10-13

7340

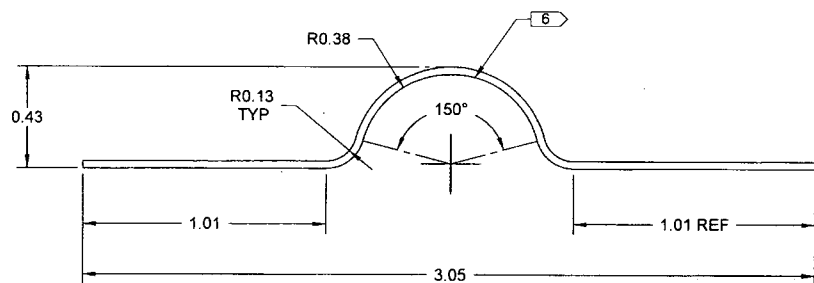
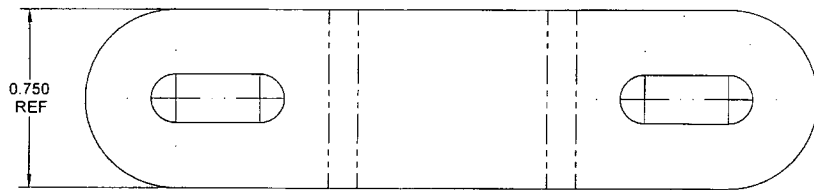
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

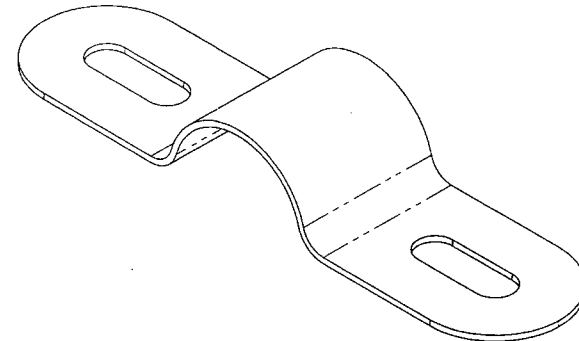
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

* NOTE: Date & initial all entries



D3777-1 CLAMP



NOTES:

- 1) MATERIAL: MAKE FROM D3777-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3777-1" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 0.02 lbs

73160

RELEASE
08-10-10

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3777	SHEET 2 OF 3
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

*NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

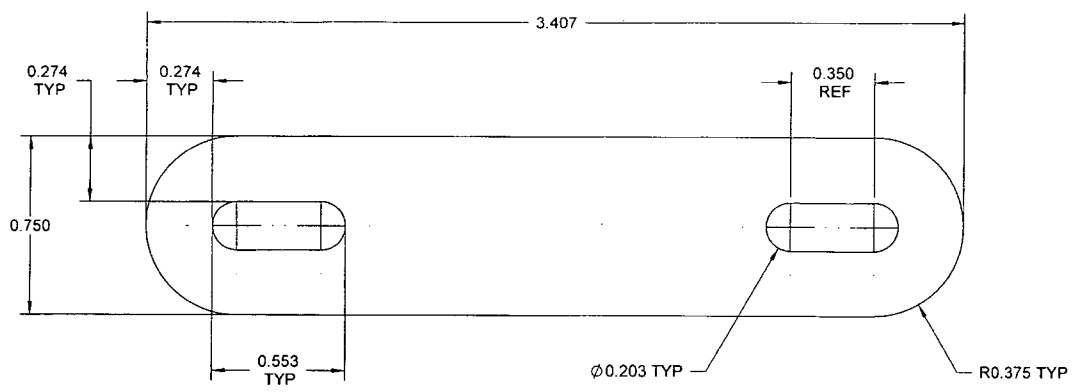
C

B

B

A

A



D3777-1F CLAMP

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 0.031 THICK (REF DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

73160

RELEASED
08-10-15-16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3777	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
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8 7 6 5 4 3 2 1

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